



BETACHROME N

HARD FACING (High Impact - Work Hardenable)



Stainless Steel Electrode for repair and maintenance Welding of Austenitic Manganese Steels

ALLOY BASIS :

C, Cr, Ni, Mn

KEY FEATURES :

- Basic coated synthetic electrode
- C-Cr-Ni-Mn type austenitic weld deposit
- Smooth arc characteristics
- High plasticity weld deposit
- Excellent heat resistance upto 900°C
- Work hardenable alloy with excellent crack resistance
- Suitable for all position

WELDING POSITION :



AC (70 OCV) /DCEP

TYPICAL APPLICATIONS :

- For joining austenitic 12% Mn steels to mild steels
- Surfacing Mn steel, Crane wheels
- Welding of unalloyed or low alloyed steels to high alloyed steels or cast steels
- Buffer layer on difficult steels before hardfacing
- Suitable for steels of difficult weldability
- Armour plates, steel castings, crusher cones, crusher hammers

REDRYING CONDITION : 250-300°C for minimum 1 hr

MECHANICAL PROPERTIES OF ALL WELD METAL :

Condition	UTS, MPa	EL%
As Welded	600	35

Machinability



Abrasion Resistance



Impact Resistance



Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	80-100	5	4	20
3.15 x 350	100-140	5	4	20
4.0 x 350	140-180	5	4	20
5.0 x 350	180-230	5	4	20

Physical Properties: With increase in number of squares, property improves